

Date: Friday, 10/5/2007 10:58:49 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	INNER FWD SADDLE		
Job Number	35034			Part Number	D5953		
Estimate Number	11079			Drawing Number	D5953 REV B		
P.O. Number				Project Number	N/A		
This Issue	10/5/2007	S.O. No.		Drawing Revision	B		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	MACHINED PARTS	Due Date	10/22/2007 Qty: 8 Um: Each		
Previous Run	32301						
Written By	<u>CH</u> 07/10/05						
Checked & Approved By							
Comment	Est Rev:E	Re-Format	05-11-29 JLM				
	Est Rev:f	ecn 826	06.12.06 EC				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	7075-T7351 8.25X7.75X2.5	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) D6101-007(7075-T7351) Size 2.50" x 7.50" X 8.25" (Grain along 7.50") Batch: <u>R31389</u>	<u>S.F 07/10/31</u>
2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3	
		Comment: HAAS CNC VERTICAL MACHINING #3	
		1-Machine as per folio D5953, Ensure Batch Number is entered	
		2-Machine Keyway	
		3-Deburr & Tumble	<u>J.L / S.F 07/10/31</u>
3.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	<u>JL / S.F 07/11/04</u>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<u>S.F 07/11/04</u>
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	<u>PF 07/11/05</u>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Job Number: 35034		Part Number: D5953
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	POWDER COATING	POWDER COATING  <i>m/05914</i>
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		 <i>Fx 07/11/06/8</i>
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION  <i>M-f 07/11/06</i>
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		 <i>8X</i>
8.0	PACKAGING 1	PACKAGING RESOURCE #1  <i>ST 421</i>
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>ST 421</i>		 <i>(8X) AB 07/11/06</i>
9.0	QC21	FINAL INSPECTION/W/O RELEASE  <i>07.11.07 JF</i>
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion	 <i>L ST-C-07</i>	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	35034
Description: Inner Fwd Saddle				Part Number:	D5953
Inspection Dwg: D5953 Rev: B				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.439	0.438	0.439	.441		
B	1.745	1.755		1.750	1.750	1.749	1.750		
C	5.245	5.255		5.249	5.250	5.248	5.250		
D	6.995	7.005		6.998	7.001	6.998	6.999		
E	5.745	5.755		5.749	5.750	5.750	5.750		
F	4.745	4.755		4.749	4.748	4.747	4.740		
G	0.315	0.322		.319	.319	.319	.319		
H	1.522	1.532		1.523	1.526	1.526	1.526		
I	3.048	3.058		3.049	3.053	3.053	3.053		
J	4.575	4.585		4.579	4.580	4.580	4.580		
K	0.313	0.318		.319	.318	.319	.319		
L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.505	.504	.502	.502		
N	1.615	1.635		1.624	1.624	1.624	1.624		
O	7.990	8.010		8.002	8.005	8.004	8.004		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		0.312	.310	.310	.310		
R	0.760	0.765		0.762	.762	.762	.762		
S	0.490	0.510		0.499	.499	.502	.500		
T	1.375	1.395		1.386	1.386	1.386	1.386		
U	2.000	2.020		2.001	2.001	2.001	2.001		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	8F
Date:	07/10/31

Audited by:	J.F.
Date:	07/11/04

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	JLM

DART AEROSPACE LTD				Work Order:	35634
Description: Inner Fwd Saddle				Part Number:	D5953
Inspection Dwg: D5953				Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	2	3	4	By	Date
A	0.438	0.443		.441	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.745	5.755		5.750	5.750	5.750	5.750		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.319	.319	.319	.319		
H	1.522	1.532		1.525	1.526	1.527	1.528		
I	3.048	3.058		3.052	3.053	3.053	3.053		
J	4.575	4.585		4.577	4.579	4.579	4.579		
K	0.313	0.318		.319	.319	.319	.319		
L	0.495	0.505		.502	.500	.499	.499		
M	0.490	0.510		.501	.499	.501	.500		
N	1.615	1.635		1.625	1.624	1.628	1.630		
O	7.990	8.010		8.006	8.002	8.001	8.001		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		.310	.310	.310	.310		
R	0.760	0.765		.760	.760	.760	.760		
S	0.490	0.510		.502	.500	.498	.502		
T	1.375	1.395		1.386	1.385	1.385	1.393		
U	2.000	2.020		2.001	2.000	2.000	2.003		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L.	Audited by:	J.F.
Date:	07/16/04	Date:	07/11/04

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
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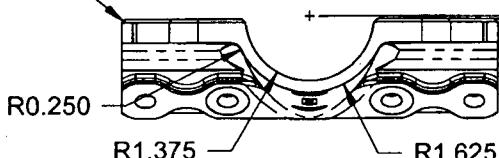
**DART**

DESIGN BW	DRAWN BY CB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>#</i>	DRAWING NO. D5953	REV. B SHEET 1 OF 1
DATE 06.11.07		TITLE INNER FWD SADDLE	SCALE 1:4

*RELEASERED*

*06.11.07 #*

CHAMFER  
0.075 X 45°  
ALL AROUND  
BOTH SIDES

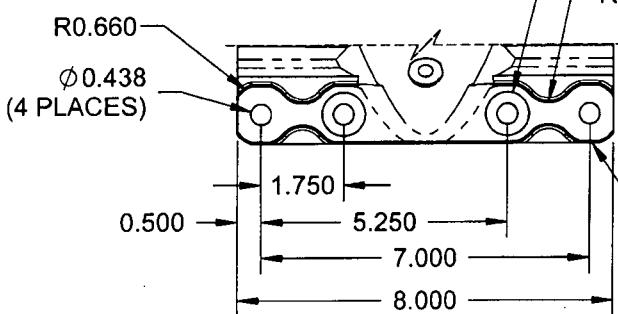


ENGRAVE PART NO.  
AND BATCH NO.  
WITH MIN RAD OF  
0.010 TO MAX  
DEPTH OF 0.010

R0.500  
Ø 0.316  
(8 PLACES)

DRILL Ø 0.316 THRU  
Ø 0.750 SPOT FACE  
(2 PLACES)

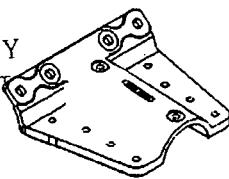
Ø 0.920 SPOT FACE  
(2 PLACES)



VIEW A-A

### D5953 INNER FWD SADDLE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *35034*



**ISOMETRIC VIEW**  
SCALE 1:8

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12  
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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